

AMENDMENTS TO THE CLAIMS

The listing of claims replaces all prior versions, and listings, of the claims in the application.

1-8 (Cancelled)

9. (New) A method of manufacturing a magnet roller in which a resin-bonded magnet material, which is composed primarily of magnetic powder and a binder, is injected into a product cavity within a metal mold while applying a magnetic field thereto, wherein the metal mold comprises a fixed metal mold forming the periphery of the product cavity and a movable metal mold forming an end of the product cavity, and wherein a magnetic field generator is disposed around the metal mold, the method comprising the steps of:

injecting the resin-bonded magnet material into the product cavity;

moving the movable metal mold by the force of the flow of the resin-bonded magnetic material injected into the cavity, such that the volume of the product cavity is increased in accordance with the amount of the resin-bonded magnet material injected into the product cavity; and

applying a magnetic field to the product cavity by the magnet field generator disposed around the metal mold while the resin-bonded magnetic material is being injected into the product cavity.

10. (New) The method according to claim 9, wherein the movable metal mold has a cylindrically-shaped recessed portion for forming a shaft portion of the magnet roller at an end of a main body portion of the magnet roller in an integral and protruding manner.

11. (New) The method according to claim 9, wherein the movable metal mold has an opening through which a shaft can be inserted, the shaft being disposed in the product

cavity in advance and penetrating through the main body portion of the magnet roller to the shaft portion of the magnet roller.

12. (New) The method according to any one of claims 9-11, wherein the injection of the resin-bonded magnet material is initiated when the state of disposition of the movable metal mold is such that the volume of the product cavity is small.

13. (New) The method according to claim 12, wherein the state of disposition of the movable metal mold in which the volume of the product cavity is small is such that the movable metal mold is disposed near an injection opening formed in the fixed metal mold, and wherein the movable metal mold is moved away from the injection opening by the force of the flow of the resin-bonded magnet material injected through the injection opening.

14. (New) The method according to any one of claims 9-11, wherein the movable metal mold is moved such that a balance is maintained between the amount of the resin-bonded magnet material that is injected and the increase in the product cavity in the fixed metal mold.

15. (New) The method according to claim 14, wherein the balance between the amount of the resin-bonded magnetic material injected and the increase in the product cavity in the fixed metal mold is maintained by a basing force in a direction in opposition to the increase in the volume of the product cavity caused by the flow of the injected magnet material.

16. (New) The method according to claim 14, wherein the balance between the amount of the resin-bonded magnet material injected and the increase in the product cavity in the fixed metal mold is maintained by a friction force between the movable metal mold and the fixed metal mold.